



FIG. 1

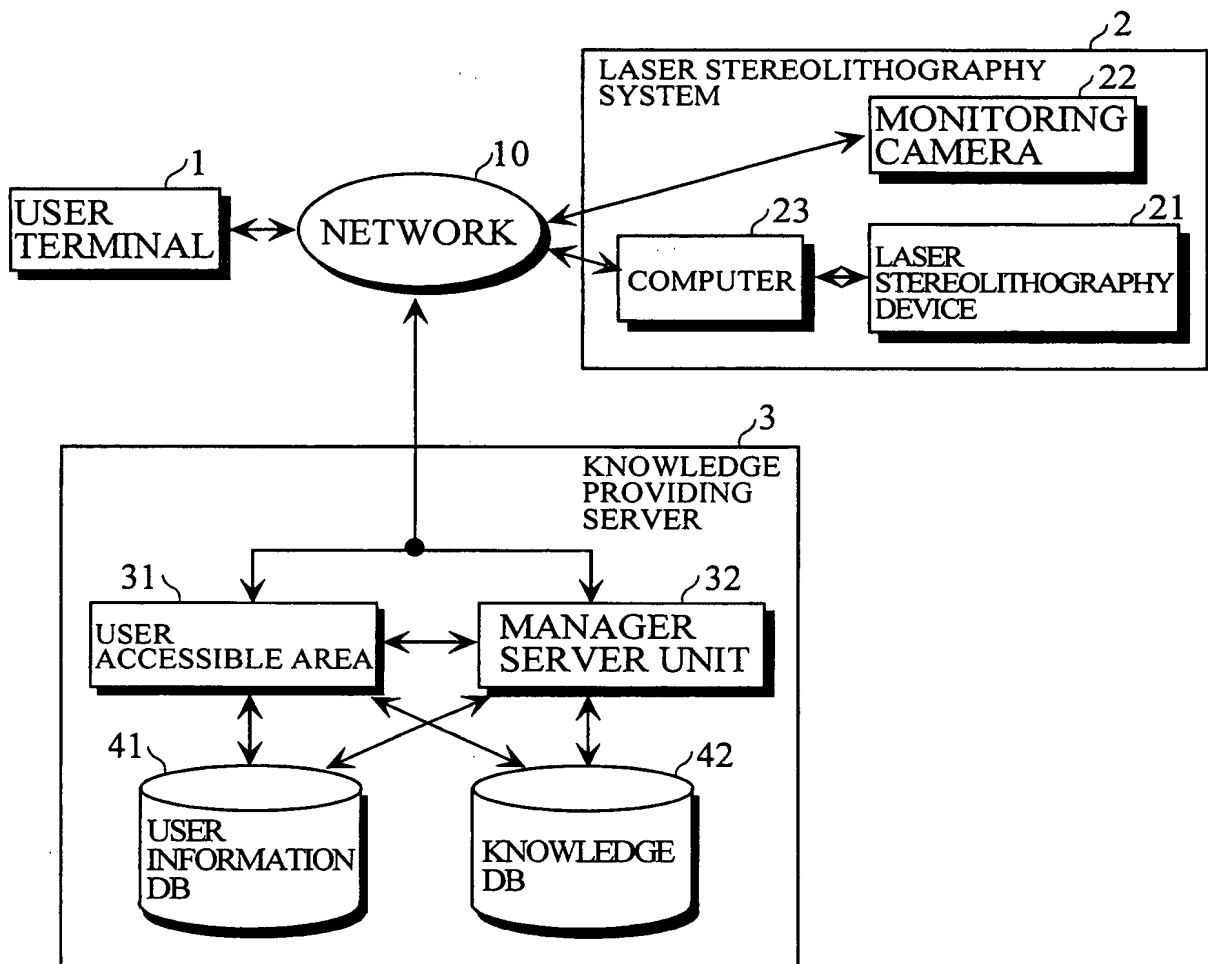


FIG. 3

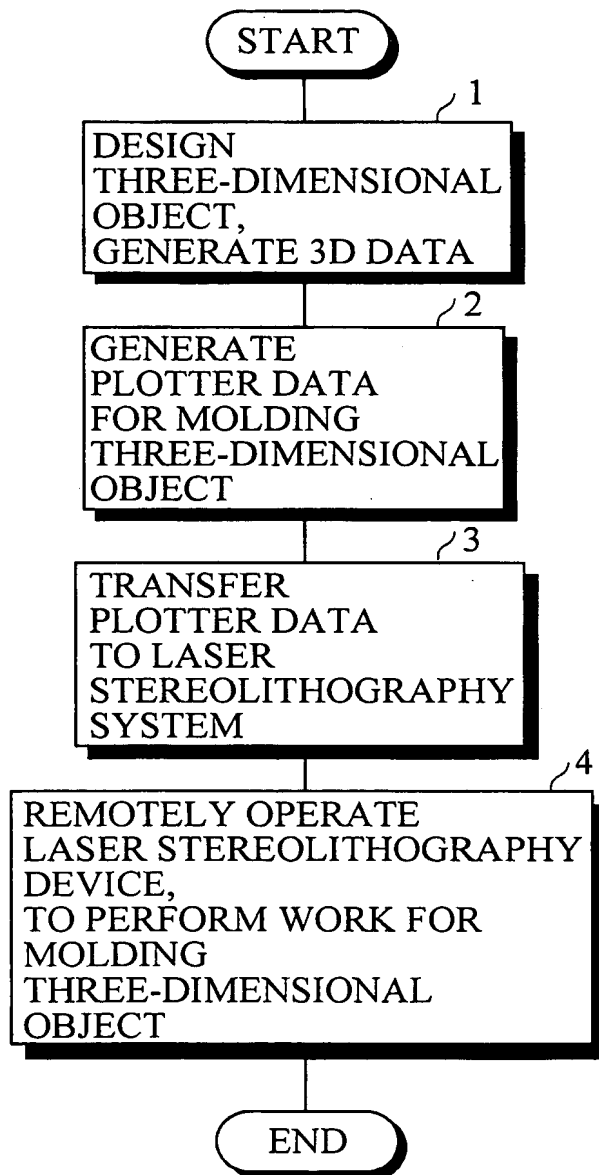


FIG. 4

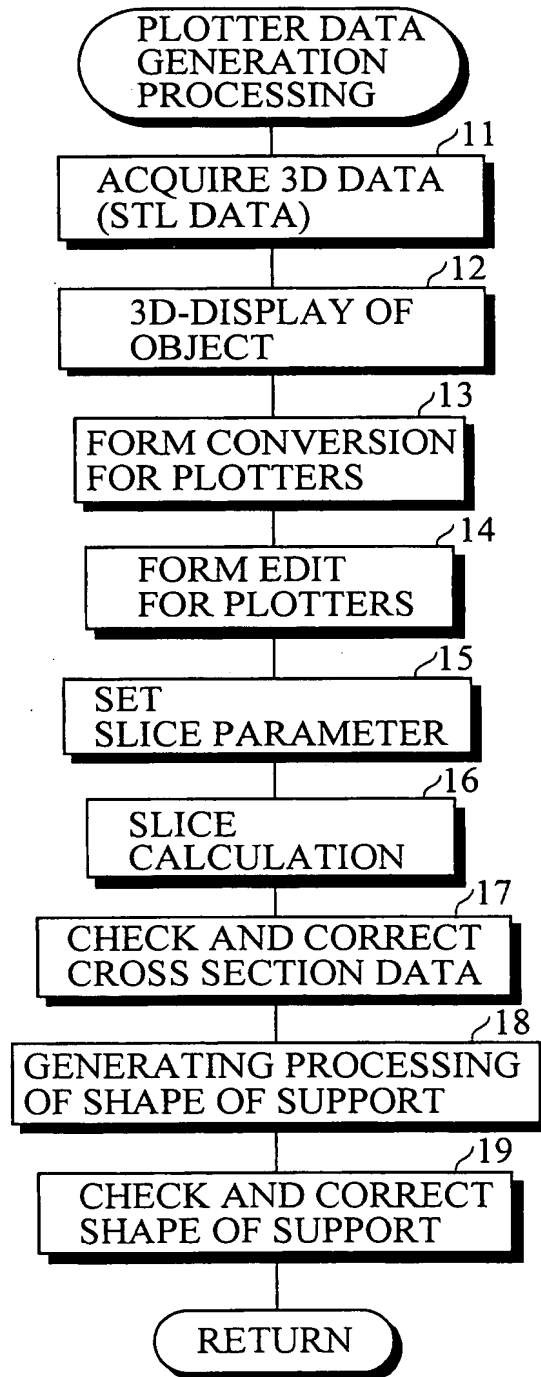


FIG.5

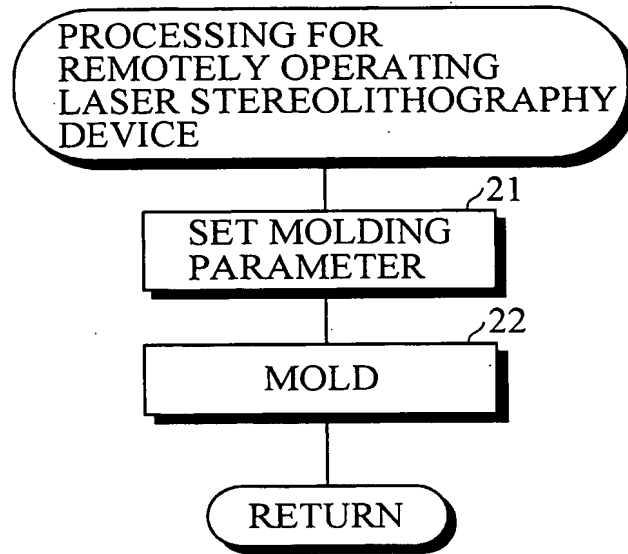


FIG.6

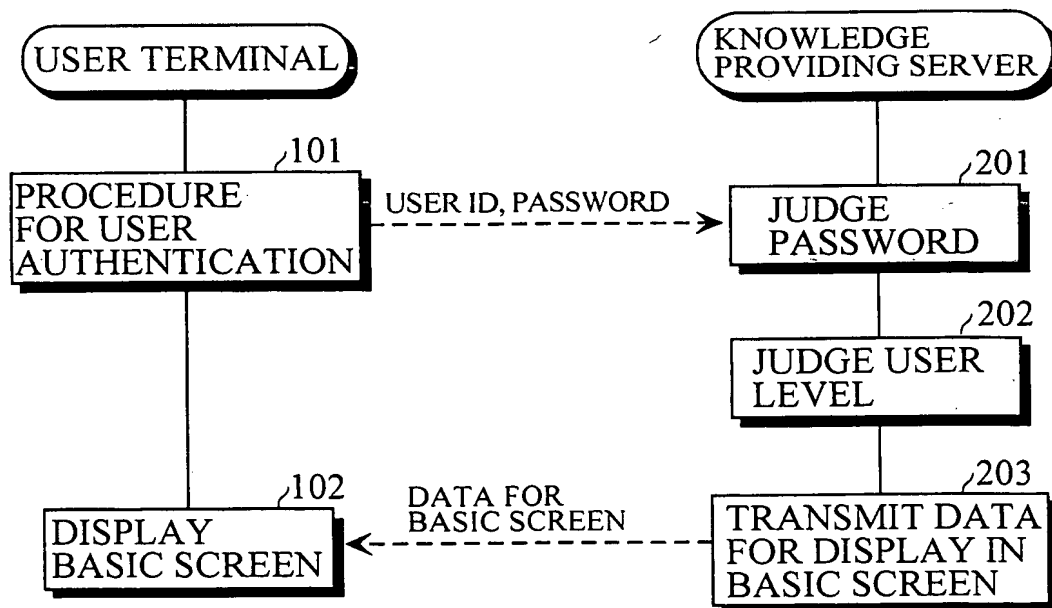


FIG.7

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)

RETURN

ADDRESS

USER ID

PASSWORD

OK

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
↩ RETURN	ADDRESS [a] http://xxxxx/xxx.xxx

<div style="display: flex; justify-content: space-between;"> [USER NAME] USER1 </div> <hr style="border-top: 1px dashed black;"/> <div style="display: flex; justify-content: space-between;"> [LEVEL OF SKILL] 1 </div>	<div style="display: flex; align-items: center;"> <div style="text-align: center; margin-right: 10px;"> ⁶¹ KNOW-HOW RETRIEVAL </div> <div style="border: 1px solid black; width: 100px; height: 40px;"></div> </div>	<div style="display: flex; align-items: center;"> <div style="text-align: center; margin-right: 10px;"> ⁶² FAILURE CASE RETRIEVAL </div> <div style="border: 1px solid black; width: 100px; height: 40px;"></div> </div>	<div style="border: 1px solid black; width: 100px; height: 40px; margin-bottom: 5px;"></div> <div style="border: 1px solid black; width: 100px; height: 40px;"></div>
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FIG.9

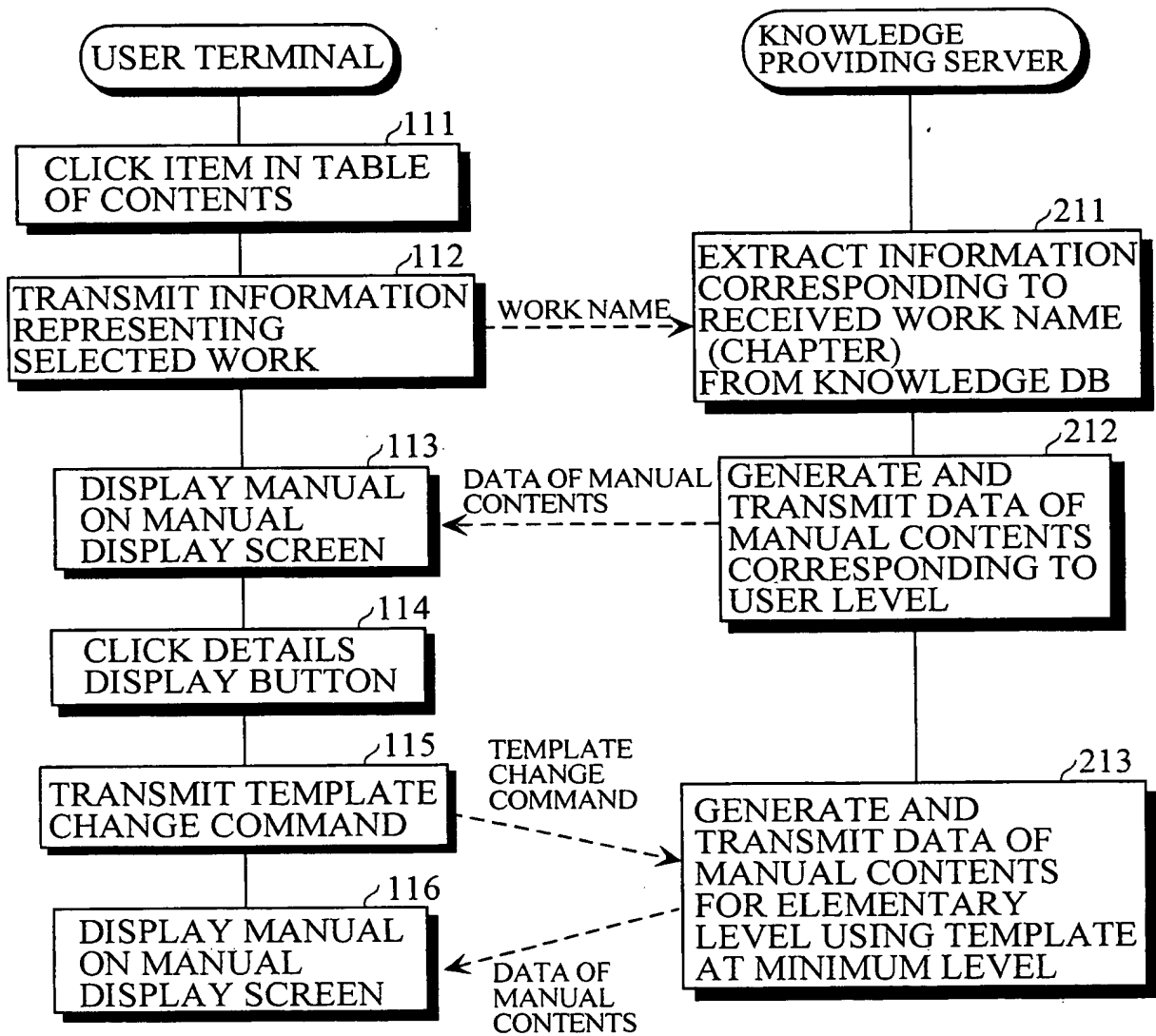


FIG.10

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
↩ RETURN	
ADDRESS http://xxxxx/xxx.xxx	
<div style="border: 1px solid black; padding: 5px;"> USER NAME USER 1 LEVEL OF SKILL 1 61 KNOW-HOW RETRIEVAL 62 63 FAILURE CASE RETRIEVAL 64 RETRIEVAL </div>	<div style="border: 1px solid black; padding: 5px;"> TABLE OF CONTENTS CHAPTER 0 BEFORE WORK CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER CHAPTER 2 EDITING OF SHAPE FOR PLOTTER CHAPTER 3 SLICING CHAPTER 4 CROSS SECTION EDITING CHAPTER 5 AUTOMATIC MAKING SUPPORT CHAPTER 6 MANUAL MAKING SUPPORT CHAPTER 7 DATA TRANSFER CHAPTER 8 REMORT OPERATION CHAPTER 9 SETTING OF LIQUID SURFACE OF RESIN CHAPTER 10 MOLDING ARRANGEMENT CHAPTER 11 COATING PARAMETER SETTING CHAPTER 12 EXPOSURE PARAMETER SETTING CHAPTER 13 MOLDING CHAPTER 14 REMOVAL CHAPTER 15 WASHING AND SUPPORT REMOVAL CHAPTER 16 SECONDARY CURING </div>
DETAILS DISPLAY 65	
CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER	
1_01 PLOTTER DATA EDITOR CONVERSION OF SHAPE FOR PLOTTER Select "① editing of a shape for a plotter" from an application menu in protter data editor. KNOW-HOW It is also possible to start plotter data editor from a start menu.	
<div style="border: 1px solid black; width: 100px; height: 100px; margin: 0 auto;"></div> IMAGE	
1_02 STL DATA READING Specify and call an STL file to be converted from a file/registration menu in a window for converting a shape for a plotter. KNOW-HOW It is possible to convert a plurality of data at a time.	
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; width: 100px; height: 100px;"></div> <div style="border: 1px solid black; width: 100px; height: 100px;"></div> </div> IMAGE	
1_03 PROCESSING CONDITION SETTING Invert the name of a model to be edited, and push "editing/processing conditions setting" to confirm a unit. KNOW-HOW Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit.	
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; width: 100px; height: 100px;"></div> <div style="border: 1px solid black; width: 100px; height: 100px;"></div> </div> IMAGE	

FIG.11

<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
<div style="text-align: center;">↩ RETURN</div>	
ADDRESS http://xxxxx/xxx.xxx <div style="float: right; border: 1px solid black; padding: 2px;">▼</div>	

<div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 61 KNOW-HOW RETRIEVAL 62 </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 63 FAILURE CASE RETRIEVAL 64 </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 64 RETRIEVAL </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> TABLE OF CONTENTS </div> <div style="padding-bottom: 5px;"> CHAPTER 0 BEFORE WORK CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER CHAPTER 2 EDITING OF SHAPE FOR PLOTTER CHAPTER 3 SLICING CHAPTER 4 CROSS SECTION EDITING CHAPTER 5 AUTOMATIC MAKING SUPPORT CHAPTER 6 MANUAL MAKING SUPPORT CHAPTER 7 DATA TRANSFER CHAPTER 8 REMOTE OPERATION CHAPTER 9 SETTING OF LIQUID SURFACE OF RESIN CHAPTER 10 MOLDING ARRANGEMENT CHAPTER 11 COATING PARAMETER SETTING CHAPTER 12 EXPOSURE PARAMETER SETTING CHAPTER 13 MOLDING CHAPTER 14 REMOVAL CHAPTER 15 WASHING AND SUPPORT REMOVAL CHAPTER 16 SECONDARY CURING </div>	<div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER 65 </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 1_01 PLOTTER DATA EDITOR CONVERSION OF SHAPE FOR PLOTTER Select "① editing of a shape for a plotter" from an application menu in protter data editor. </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 1_02 STL DATA READING Specify and call an STL file to be converted from a file/registration menu in a window for converting a shape for a plotter. </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 1_03 PROCESSING CONDITION SETTING Invert the name of a model to be edited, and push "editing/processing conditions setting" to confirm a unit. </div> <div style="border-bottom: 1px dashed black; padding-bottom: 5px;"> 1_04 START OF PROCESSING Execute conversion processing. </div> <div style="padding-bottom: 5px;"> 1_05 TERMINATION OF APPLICATION Select "the end of an application" from a menu, to perform termination processing. </div>
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FIG.12

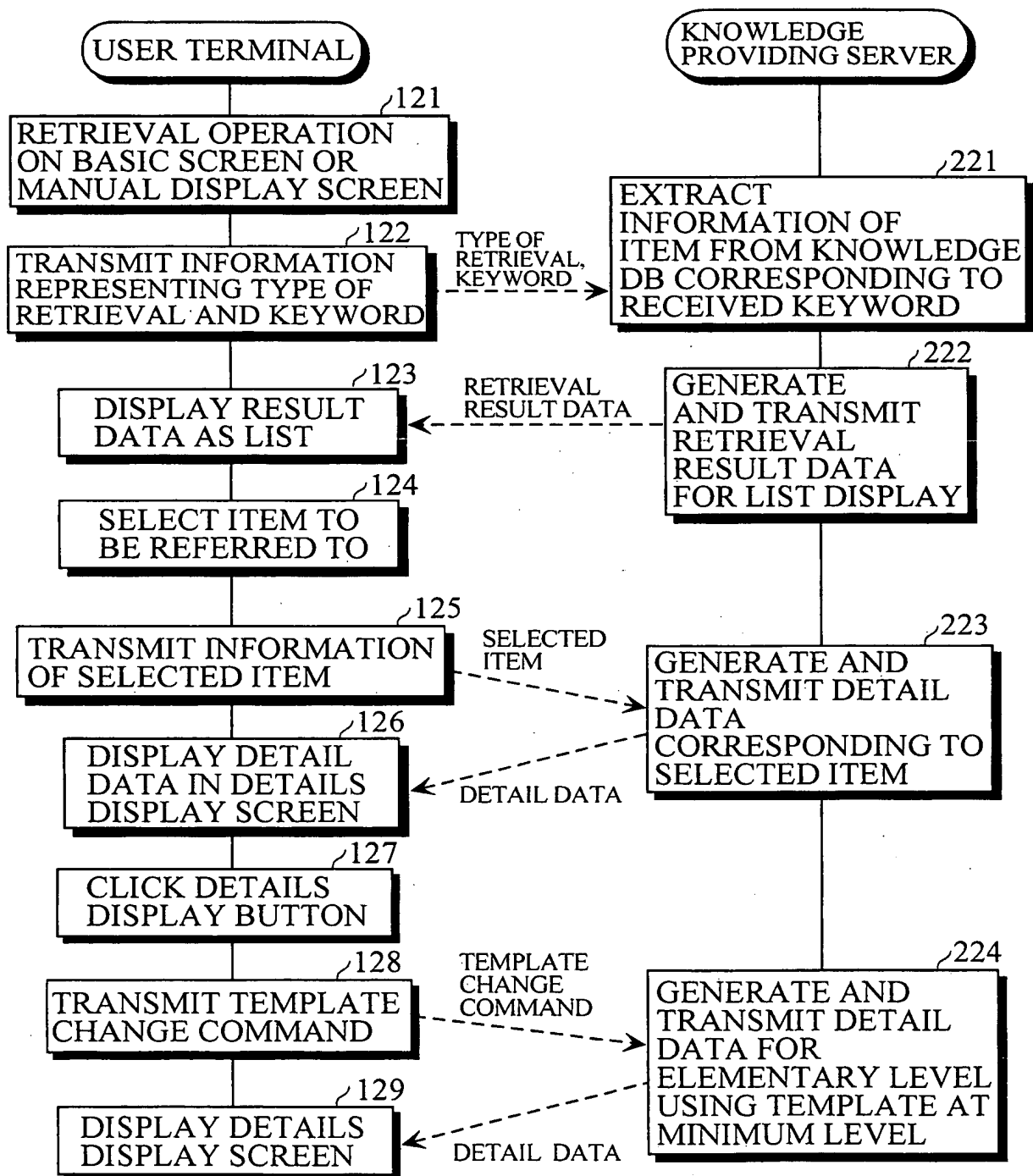




FIG.13

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)

⬅ RETURN

ADDRESS  http://xxxxxx/xxx.xxx 

LIST OF RESULTS

NUMBER OF CLAUSE	WORK NAME	PRECONDITIONS + KNOW-HOW
1_03	Processing Condition Setting	<u>Generally, millimeter is a unit.</u> <u>Confirm because there is a case where inch</u> <u>or the like is a unit.</u>

FIG. 14

<div style="float: right; text-align: right;"> <input type="button" value="X"/> <input type="button" value="□"/> <input type="button" value="■"/> </div>										
FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)										
↩ RETURN	<div style="border: 1px solid black; padding: 2px;"> ADDRESS http://xxxxx/xxx.xxx </div>									
<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="flex-grow: 1;"> <h2 style="margin: 0;">DETAILS DISPLAY</h2> </div> <div style="border: 1px solid black; padding: 2px; font-size: 0.8em;"> DETAILS DISPLAY </div> </div>										
<div style="border: 1px dashed black; padding: 10px;"> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; padding: 10px; vertical-align: top;"> KNOW-HOW </td> <td style="width: 40%; padding: 10px; vertical-align: top;"> Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit. </td> <td style="width: 30%; padding: 10px; vertical-align: top;"> IMAGE </td> </tr> <tr> <td style="width: 30%; padding: 10px; vertical-align: top;"> RELATED IMAGE </td> <td style="width: 40%; padding: 10px; vertical-align: top;"> IMAGE </td> <td style="width: 30%; padding: 10px; vertical-align: top;"> IMAGE </td> </tr> <tr> <td style="width: 30%; padding: 10px; vertical-align: top;"> CASE WHERE THIS KNOW-HOW IS NOT USED </td> <td style="width: 40%; padding: 10px; vertical-align: top;"> Molded in different size </td> <td style="width: 30%; padding: 10px; vertical-align: top;"> IMAGE </td> </tr> </table> </div>		KNOW-HOW	Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit.	IMAGE	RELATED IMAGE	IMAGE	IMAGE	CASE WHERE THIS KNOW-HOW IS NOT USED	Molded in different size	IMAGE
KNOW-HOW	Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit.	IMAGE								
RELATED IMAGE	IMAGE	IMAGE								
CASE WHERE THIS KNOW-HOW IS NOT USED	Molded in different size	IMAGE								

FIG.15

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)

RETURN

ADDRESS <http://xxxxxx/xxx.xxx>

LIST OF RESULTS

FAILURE	CAUSE
A molding time period is lengthened.	Because it takes long to perform exposure and coating per layer.
A knife is brought into contact with a model for a long time so that the model is liable to be destroyed when a molding time period is increased and the knife moves.	Because the distance a knife moves is increased, and the probability that the knife is caught by the model is increased.

FIG.16

DETAILS DISPLAY	
FAILURE	A molding time period is lengthened.
CAUSE	Because it takes long to perform exposure and coating per layer.
KNOW-HOW AT THIS TIME	When it is desired to shorten a molding time period, the height in the Z direction is reduced to make the number of stacked layers as small as possible.
RELATED KNOWLEDGE	Rotate by editing of a shape for a plotter in the direction in which the height is minimized.

FIG.17

